

SP/11

Work Order ID 52660-1



Page 1

October 5, 2009 2:53:38 PM

Item ID: D206-547-043

Accept



Setup Start



Revision ID: F

Stop



Item Name: Console High Slope

Start Date: 05/10/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 27/10/2009 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: RLDate: 09-10-5

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D206-547

Rev F

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Cut D2710-1, D2710-2, D2710-3, D2710-4 from D2024 Extrusion as per Dwg D2710 and templates DT 8264-1, DT 8264-2, DT8264-3, DT8264-4 □ 2-Debur

09/10/19 (8)

110

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Grind weld relief chamfer as per Dwg D206-547 □ 2-Rivet extrusion to sides as per Dwg D206-547 using Rivet MS20470AD3-4

09/10/20 (8)

120

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

⇒ 09/10/21

Quality Control

XSKH  
KSKH

f



# Work Order ID 52660

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Item ID: D206-547-043

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Setup Start



Revision ID: F

Stop



Item Name: Console High Slope

Start Date: 06/10/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 27/10/2009 Req'd Qty: 6.00

Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Large Fab	Large Fab	0.00							
Large Fab	Memo 1-Tack weld as per Dwg D206-547□A/R Batch: <u>H108436</u> <u>2-GRIND</u>	0.00 AL ROD							
140  QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							
150  QC	QC10- Inspect visual per QSI004- ground welds	0.00							
Quality Control	Memo	0.00							

*Pl 09 10 23*

*=> 808/10/20*

*X6LH  
X6RH*

*=> 808/10/20*

*X6LH  
X6RH*



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Item ID: D206-547-043

Accept



Setup Start



Revision ID: F

Item Name: Console High Slope

Stop



Start Date: 06/10/2009 Start Qty: 6.00

Required Date: 27/10/2009 Req'd Qty: 6.00



Crst Item ID:

Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	1-Rivet sides and brackets per Dwg D206-547 using Rivet MS20470AD3-3								
170 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
180 	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 8:00am OVEN TEMPERATURE: 320°F FINISH TIME: 8:30am								

*Ep09/10/26* (6)

*=> 02/10/26*

(x6) *f*

*=> Jtl 09/10/27*

(x6) *x*





# Work Order ID 52660

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Item ID: D206-547-043

Accept



Setup Start



Revision ID: F

Stop



Item Name: Console High Slope

Start Date: 06/10/2009 Start Qty: 6.00



Cust Item #:

Required Date: 27/10/2009 Req'd Qty: 5.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

190

QC3- Inspect Part Finish

0.00



umo 09/10/27

Y6

QC

Memo

0.00

Quality Control

200

Identify as per dwg & Stock Location: store

0.00



9/10/28 (bx) sf

Packaging

Memo

0.00

Packaging

210

QC21- Final Inspection - Work Order Release

0.00



09/11/18

QC

Memo

0.00

Quality Control

mf

09-10-28





# Picklist Print

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Page 1

Work Order ID: 52660

Parent Item: D206-547-043RevF

Parent Item Name: Console High Slope

Comments:

Start Date: 06/10/2009

Required Date: 27/10/2009

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS20470AD3-4

Purchased

No

100

Each

12,043.00

120.0000



Rivet, Universal Head

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

12043

111477

8332

15541

3711

110

f

1,273.160

21.6000

D2024RevC

Manufactured

No



Console Extrusion

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1273.16

1

1273.16

110

Each

7.0000

6.0000

D2602-1RevB

Manufactured

No



Console Side, 206 Console

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

7

43752

1

51779

6

B50406

80

EP 09/10/20

160

EP 09/10/15

MOI

EP 09/10/19



# Picklist Print

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Work Order ID: 52660



Parent Item: D206-547-043RevF



Parent Item Name: Console High Slope

Start Date: 06/10/2009

Required Date: 27/10/2009

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2602-2RevB 		Manufactured	No			110	Each	7.0000	6.0000 		09/10/19	
Console Side, 206 Console												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1

46249

1

Main Warehouse

ST177

6

50255

6

B52697 (8A)

D2606RevA1



Console Bracket, 206/407 Console

Manufactured No

110

Each

13.0000

6.0000

09/10/20

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

13

48442

13

6

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Shop Packet Print

Page 2



# Picklist Print

Page 3

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Work Order ID: 52660



Parent Item: D206-547-043RevF



Parent Item Name: Console High Slope

Start Date: 06/10/2009

Required Date: 27/10/2009

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2607RevA1

Manufactured

No

110

Each

23.0000

6.0000



Bracket, 206 Console

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

23

32820

7

50327

16

110

Each

8,586.000

48.0000

MS20470AD3-3

Purchased

No



Rivet, Universal Head

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

8586

1065

1435

16941

7151

*9/509/10/26*

*1/5*

*9/509/10/26*

*64*

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Shop Packet Print

Page 3







DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED KE	DRAWING NO. D206-547	REV. F SHEET 1 OF 5
DATE 99.02.11		TITLE CONSOLE ASSEMBLY	SCALE NTS
-	82.11.23	NEW ISSUE	
A	83.01.18	REDRAWN, ADD NOTE 4	
B	84.10.23	D206-547 WAS 01.B.81.017	
C	89.03.30	REDRAWN	
D	90.12.06	COMPANY NAME CHANGE MS20470 WAS MS20426 DIM 1.312 WAS 1.0, 13.160 WAS 12.85	
E	97.10.22	REDRAWN, ADD -043, -045, -047	
F	99.02.11	ADD MS20470AD3-3 RIVET (NC 143) UPDATED WELD DETAIL	

**RELEASED**  
99.03.05 RE  
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 52660 BA 09-10-5

-041	-043	-045	-047	PART NUMBER	DESCRIPTION
X				D206-547-041	CONSOLE ASSEMBLY
	X			D206-547-043	CONSOLE ASSEMBLY
		X		D407-547-045	CONSOLE ASSEMBLY
			X	D407-547-047	CONSOLE ASSEMBLY
1				D2601-1	CONSOLE SIDE
1				D2601-2	CONSOLE SIDE
	1			D2602-1	CONSOLE SIDE
	1			D2602-2	CONSOLE SIDE
		1		D2603-1	CONSOLE SIDE
		1		D2603-2	CONSOLE SIDE
			1	D2604-1	CONSOLE SIDE
			1	D2604-2	CONSOLE SIDE
1		1		D2605	CONSOLE BRACKET
	1		1	D2606	CONSOLE BRACKET
1	1			D2607	CONSOLE BRACKET
		1	1	D2608	CONSOLE BRACKET
1		1		D2709-1	CONSOLE SIDE RAIL
1		1		D2709-2	CONSOLE SIDE RAIL
1		1		D2709-3	CONSOLE SIDE RAIL
1		1		D2709-4	CONSOLE SIDE RAIL
	1		1	D2710-1	CONSOLE SIDE RAIL
	1		1	D2710-2	CONSOLE SIDE RAIL
	1		1	D2710-3	CONSOLE SIDE RAIL
	1		1	D2710-4	CONSOLE SIDE RAIL
10	8	8	6	MS20470AD3-3	RIVET
18	20	18	20	MS20470AD3-4	RIVET



**DART**

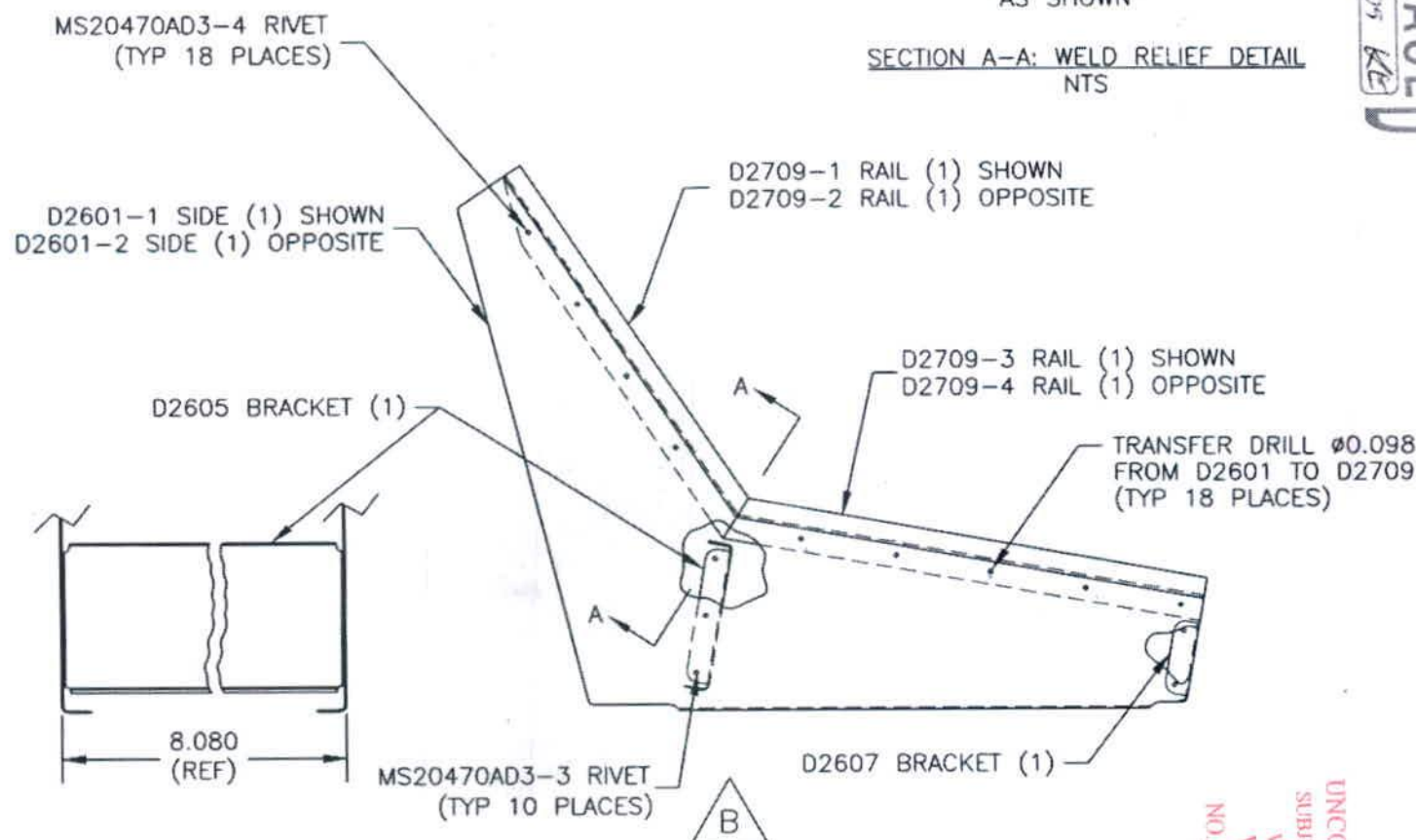
RELEASED  
M0305 KE

DESIGN	BW	DRAWN BY	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	JP	APPROVED	KE	
DATE	99.02.11	TITLE	D206-547 CONSOLE ASSEMBLY	REV. F SHEET 2 OF 5 SCALE 1:4



GRIND RELIEF  
CHAMFER FOR WELD  
0.040-0.050 x 45°  
AS SHOWN

SECTION A-A: WELD RELIEF DETAIL  
NTS



D206-547-041 (206 LOW SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WITHOUT NOTICE  
WORK ORDER  
NO. 52000





**DART**

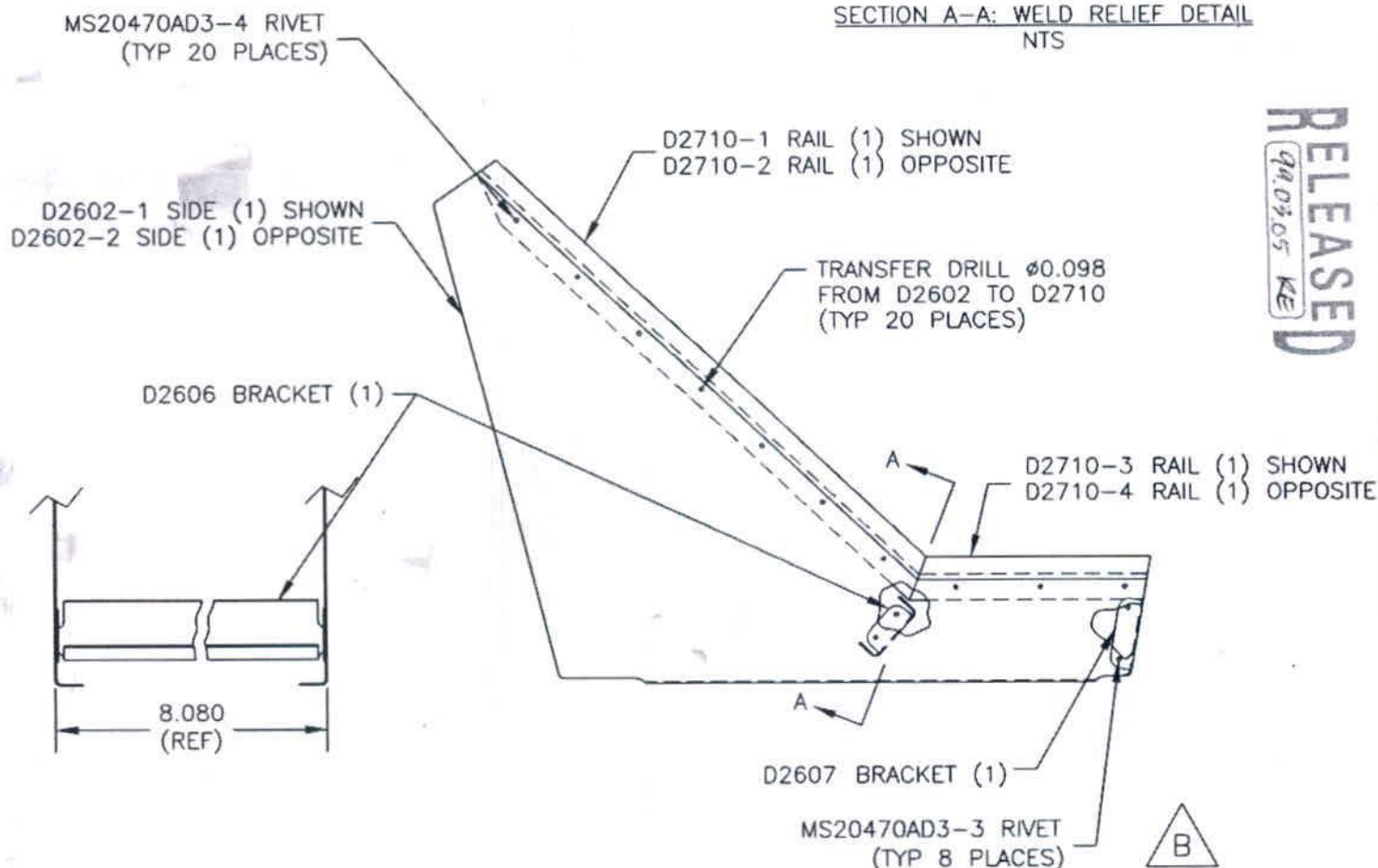
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CHECKED JP	APPROVED KE	DRAWING NO. D206-547	SHEET 3 OF 5
DATE 99.02.11	TITLE CONSOLE ASSEMBLY	SCALE 1:4	

RELEASED  
99.07.05 KE



GRIND RELIEF  
CHAMFER FOR WELD  
0.040-0.050 x 45°  
AS SHOWN

SECTION A-A: WELD RELIEF DETAIL  
NTS



D206-547-043 (206 HIGH SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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SUBJECT TO AN ENDORSEMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 52440



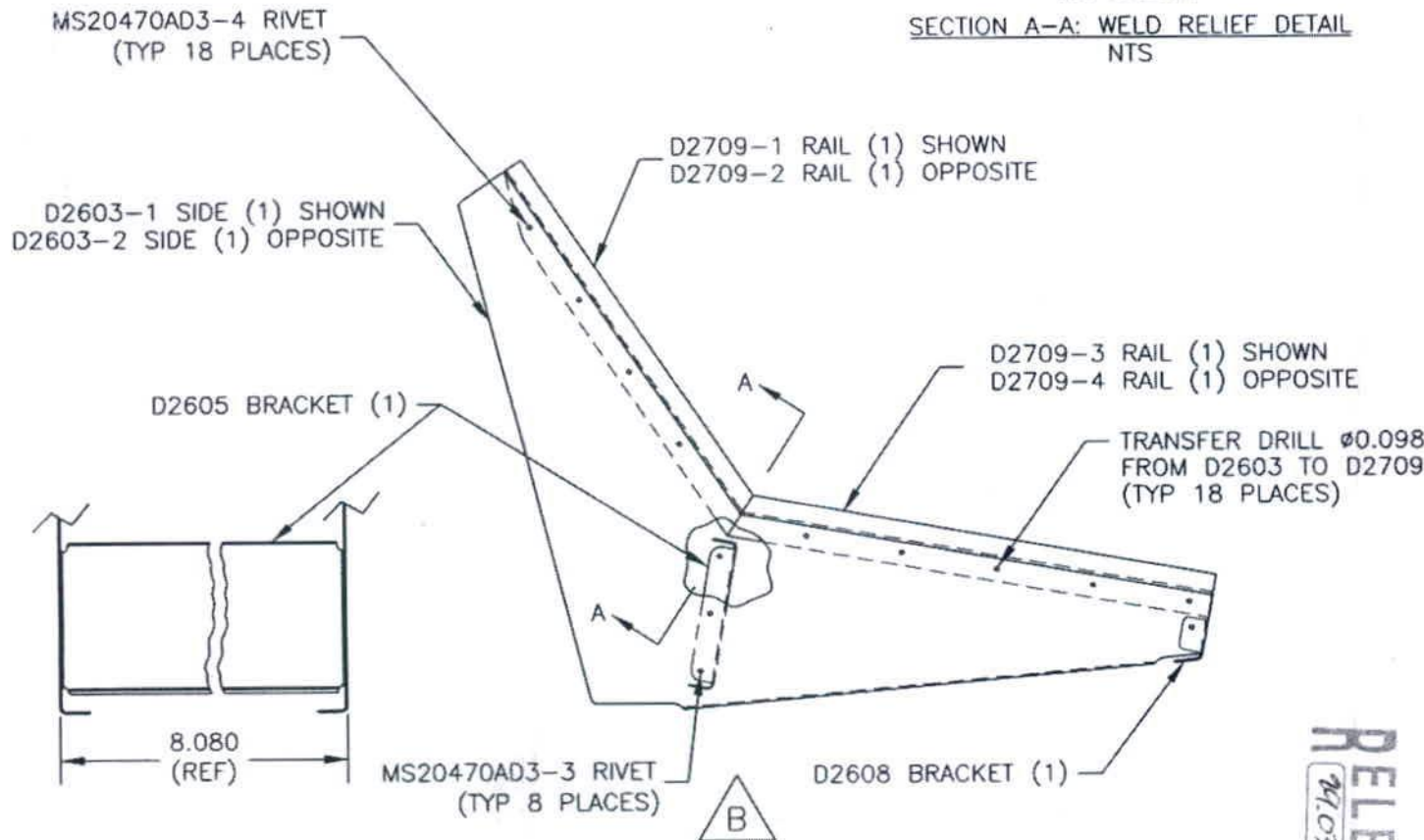


**DART**



GRIND RELIEF  
CHAMFER FOR WELD  
0.040-0.050 x 45°  
AS SHOWN

SECTION A-A: WELD RELIEF DETAIL  
NTS



D407-547-045 (407 LOW SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED UP	APPROVED KE	DRAWING NO. D206-547
DATE 99.02.11	TITLE CONSOLE ASSEMBLY	REV. F SHEET 4 OF 5 SCALE 1:4

**RELEASED**  
NO. 0305 KE  
SHOP COPY  
RETURN TO  
ENGINEERING

UNCONTROLLED  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK C.R.T.V.  
NO. 54444

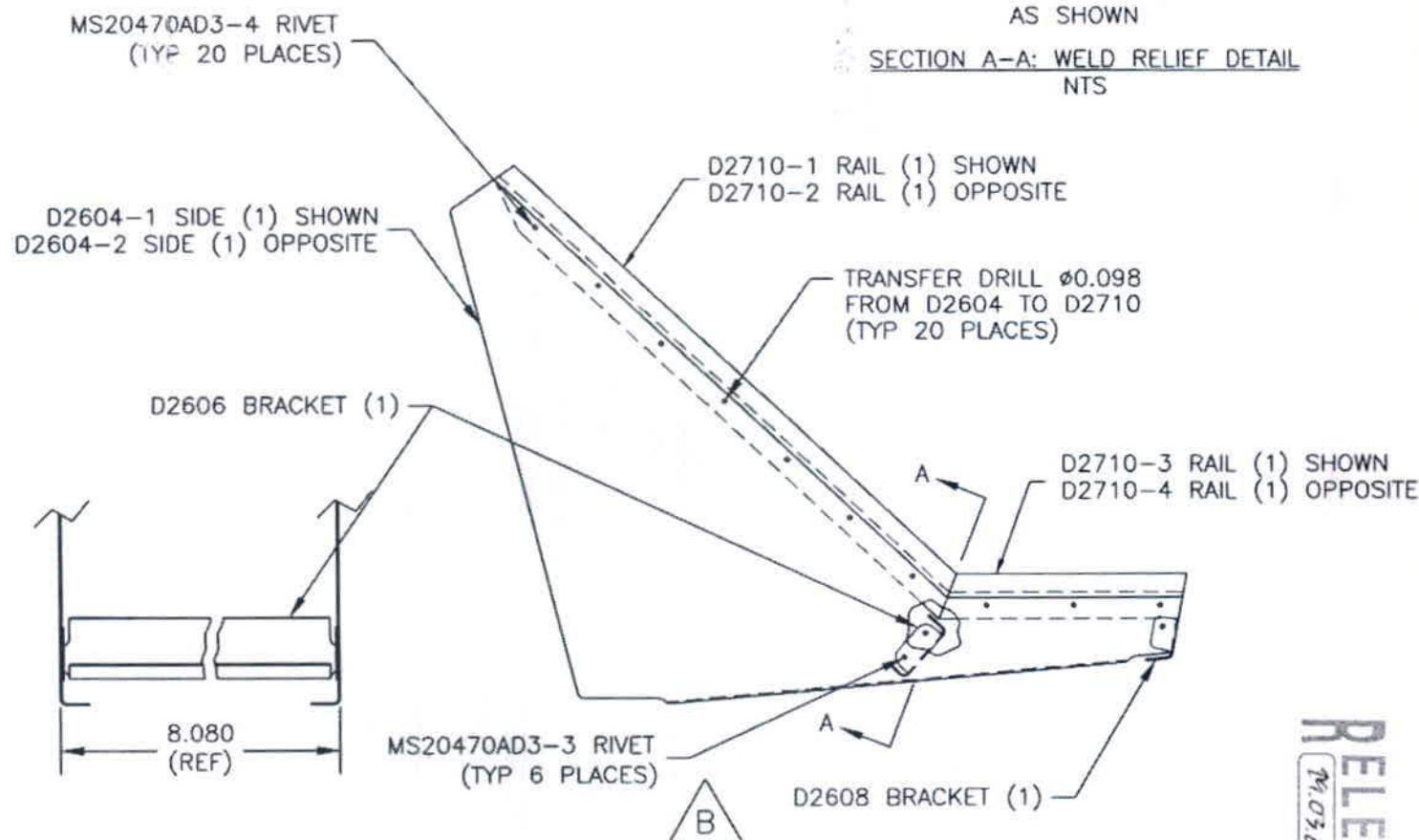


**DART**



GRIND RELIEF  
CHAMFER FOR WELD  
0.040-0.050 x 45°  
AS SHOWN

SECTION A-A: WELD RELIEF DETAIL  
NTS



D407-547-047 (407 HIGH SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**RELEASED**  
NO. 0305 KE

SHOP COPY  
RETURNS TO  
ENGINEERING  
CONTROL LTD. COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 58444

DESIGN Bw	DRAWN BY RF	DART AEROSPACE LTD HAMMERSBURG, ONTARIO, CANADA	
CHECKED C	APPROVED KE	DRAWING NO. D206-547	REV. F
DATE 99.02.11	TITLE CONSOLE ASSEMBLY	SHEET 5 OF 5	SCALE 1:4



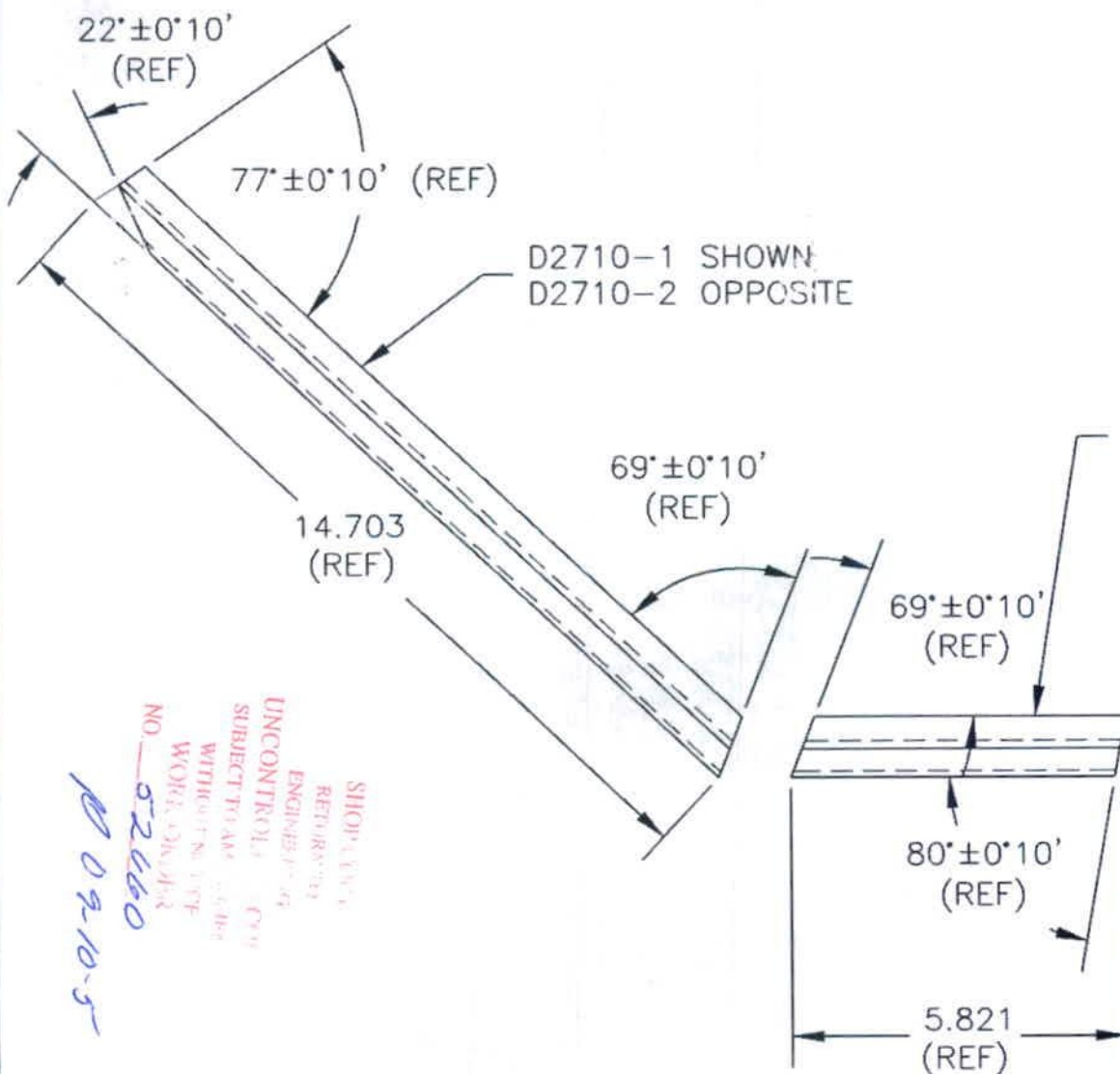


**DART**

DESIGN		DRAWN BY		DART AEROSPACE LTD	
BW		RF		HAMKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.		REV. B	
CP	KE	D2710		SHEET 1 OF 1	
DATE	TITLE	SCALE			
99.02.11	CONSOLE SIDE RAIL	1:3			
A	97.10.25	NEW ISSUE			
B	99.02.11	DELETE WELD, ADD TEMPL. (TSR A1020)			

D2710-3 SHOWN  
D2710-4 OPPOSITE

D2710-1 SHOWN  
D2710-2 OPPOSITE

**RELEASED**  
99.02.05 KE

MATERIAL: MAKE FROM D2024 EXTRUSION  
MAKE PER TEMPLATE # DT8264  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP CHECK  
RETURNED  
ENGINEER'S  
UNCONTROLLED  
SUBJECT TO AM  
WITH NO TYPE  
WORK, QIN, JIN  
NO. 52660  
P 02.10.5

